

Work Order ID 127625

127625

Page 1

December-17-14 1:40:56 PM

Item ID: D3411-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Washer
 Start Date: 12/15/14 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 12/17/14 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 14-12-19 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3411	REV A								

100 0.00
100
 Hardinge Memo 0.00 46 36
 Hardinge CNC Lathe Small Turn as per Folio FA591 Rev: 4A & Dwg D3411 Rev: 9 15.01.04
 Deburr & Tumble as per Dwg D3411

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 46 36
 Quality Control 15.01.04

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 46 36
 Quality Control 15-1-4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127625***127625***

Page 2

Item ID: D3411-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Washer

Stop ***NS2***

Start Date: 12/15/14 Start Qty: 40.00

40

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 2037

0.00

130

Packaging

Memo

0.00

Packaging

(46 X)

DAS
46
0.39

JAN 06 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

15/1/10

15-6

DQA: _____ Date: _____



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Picklist Print

December-17-14 1:40:56 PM

Page 1

Work Order ID: 127625

127625

Parent Item: D3411-3

D3411-3

Parent Item Name: Washer

Start Date: 12/15/14

Required Date: 12/17/14

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.10.19New issueKJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINR1.000		Purchased	No			100	f	49.0000	0.0136	1			

MDFI RINR1 000

Delrin Round Bar 1" color: black

Location

Loc Qty

Loc Code

MAT039

49

m130188

49

~~MAT039~~ S

1.0 BG 15.01.04

DQA: _____ Date: _____



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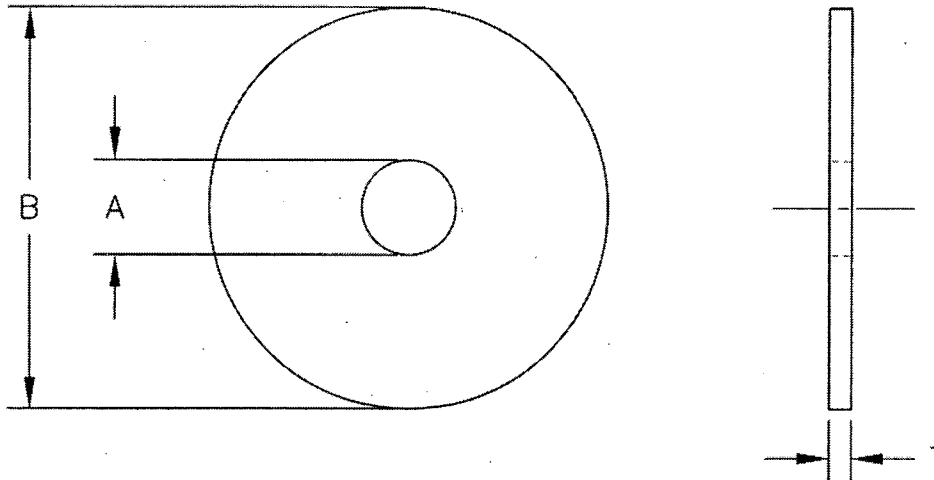
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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3411	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE WASHER, DELRIN	SCALE NTS
A	05.03.16	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



1) SPECIFICATION: **D3411-X WASHER**

DASH No.

RELEASED
05.09.06 *[Signature]*

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH NO.	BOLT SIZE	A (in)	B (in)	T (in) ±0.006	NON-METALLIC REPLACEMENT FOR:
-3	#10	0.203	0.875	0.063	AN970-3
-4	1/4	0.265	1.125	0.063	AN970-4
-5	5/16	0.328	1.375	0.063	AN970-5
-6	3/8	0.390	1.625	0.063	AN970-6
-7	7/16	0.453	1.812	0.109	AN970-7
-8	1/2	0.515	2.000	0.109	AN970-8

- 2) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

NO. 127621745
14/12/19
WORK ORDER
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UNCONTROLLED COPY
ENGINEERING
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SHOP COPY

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